Work Orde May-29-12 2:50	er ID 84928 5:22 PM			*849	728*	72	in 8 <del>-</del>	<del></del>	7474 ° 774-		Page
Item ID: Revision ID: Item Name:	D209-669-043 Replacement Skidtube	=		Accept	*N900	040	100	)* s	Setup Star	1/7	S1*
Start Date: Required Date: Reference:	29/05/2012 Start Q	ety: 1.00 Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		÷		^N	S2*
Approvals:	Process Plan:QC:	.J	Date: 12/05/2	Tooling: SPC (Y/N):		ate:		Ą	Run Start Stop	"1/1	R1*
Sequence ID/ Work Center II		tion		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp.
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D2906	Rev B										
*100 *100* DC Document Control	DOCUME	ENT CONTROL  Memo Photocopy D		0.00 0.00 abels per PPP D205-669-6	003 043 Chg 002 PEV 2	EN 125	<del>2</del> 9				× .
*110 <b>*</b>	Skidtubes			0.00					Ċ		
Skidtubes		Memo		0.00			,	0//	0	-	
Skidtubes		-Drill pilot he cutting fluid)		9, DT8711-2 & DT8711-3	(Do not use	CF	/0	2.6.12	3	(*)	
*)		-Deburr and b	o 0.500" as per Dwg D29 blow out all chips from d Alodine tube per QSI 00			SAK	) /c	2.06 B	-18		
							Ma	12	6-19	æ	

DATE STEF	1		OIIDEII O	HANGES	- :			-	
7 012	Р	ROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approva QC Inspecto
4.06.19 DC	change Oc	3 to QCZ			A			120713	245 245
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NCR:		W	ORK ORD	ER NON-CONFORMANCE	(NCR)	· (4)	A.	
		Description of NC	- 13	Corrective Action Section B		Verification		
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	QC inspector
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NOTE: Date & initial all entries

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\*84928\*

Page 3

	0209-669-043	Accept	*N90004010	* Setup Start *NC1*
Revision ID:				
Item Name: R	Replacement Skidtube	*	•	Stop *NS2*
Start Date: 2	9/05/2012 Start Qty: 1.00	*1*	Cust Item ID:	
Required Date: 1	6/07/2012 Req'd Qty: 1.00	*1*	Customer:	
Reference:	•	•		
Approvals:	Process Plan: Date:	Tooling:	Date:	Run Start *NR1*
	QC: Date:_	*** SPC (Y/N):	Date:	*NR2*
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID Tool # Plan Code	Accept Reject Reject Insp. Qty Qty Number Stamp
140		0.00	÷	
*1 <u>4</u> <b>∩</b> * CNC Bend 1	BENDING MACHINE - CROSSTUI  Memo	BES 0.00		
CNC Delta 100 Bender		COB43FWD & COBRAFT on CNC E	Bender and Folio FT	12/06/20
	2-Cut tubes as per Dwg.	D2906		
150		0.00		
*150*	Skidtubes	0.00		
Skidtubes	Memo	. 0.00	05 12 6:20	
Skidtubes .	-Deburr ends and remov		CF 12.6.20	
	- Insert D4202-1 spacer, and dwg. Hold x-bolt wit expantion and finish with	swage as per QSI002 and trim/ grind th DT9701 Use tube expander 1/2 x1 h 1/2 x 18G to achieve dwg dimention	flush per QS1002 (1 12-74) 7G to start n. 18 12/07/09	
160	QC5- Inspect part completeness to sto	ep on W/O 0.00		
*160*	Memo	0.00		1 0 3007/04
Quality Control				

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W/O:			W	ORK ORDER CHANGE	S				
DATE STEP PROCEDURE CHANGE By Date Qty Chief Eng Prod Mg		Approval Chief Eng / Prod Mgr	Approval QC Inspector						
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7.									
Part No		PAR #:							
Resolution:		esolution:	Dispositio	n: <u>'</u>	QA: N/C CI	osed:	•	Date: _	
NCR:			WORK ORD	ER NON-CONFORMAI	NCE (NCF	l)			
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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Work Orde May-29-12 2:56		928		*849	728*	- T TATE (***)	·				Page 4
Item ID: Revision ID:	D209-669-0	43		Accept	*N900	0401	100*	' Se	tup Star	't *N	IS1*
Item Name:	Replacement	Skidtube							Sto	P *N	S2*
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item l Customer:	ID:				I	
Approvals:	Process Pla	ın:	Date:	Tooling:	D	ate:		Ru	ın Star	't *N	R1*
	QC:		Date:	SPC (Y/N):		ate:			Stop	° *N	R2*
Sequence ID/ Work Center II	)	Operation Description		Set Up/ Run Hours	Tool ID			ccept ty	Reject Qty	Reject Number	Insp. Stamp
*170* Skidtubes	ž.,	Large Fab Memo		0.00		۵			_\$	(AD	12-07-
Skidtubes & **		not to hit we	eb.Deburr	3217 Open holes to 19/64",							
				open holes to .640	/						

190

QC5- Inspect part completeness to step on W/O

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Memo

Quality Control

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W/O:			W	ORK ORDER CHANG	ES			+	
DATE	STEP	PRO	CEDURE CH	ANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		**							
Part No		PAR #:							
	R	esolution:	Dispositi	on: '	_ QA: N/C	Closed:		Date: _	
NCR:		`\	WORK ORI	DER NON-CONFORMA	ANCE (NO	R)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section  Action Description  Chief Eng	on B Sigr	la Soci	cation ion C	Approval Chief Eng	Approval QC Inspector
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Work Orde May-29-12 2:56		928		*84	928*	· · · · · · · · · · · · · · · · · · ·	· 7			Page	: 5
Item ID: Revision ID: Item Name:	D209-669-0 Replacement			Accept	*N900	04010	<b>7</b> 0*	Setup	Start Stop	*NS1* *NS2*	
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:					
Approvals:	Process Pla	an:	Date:	Tooling: SPC (Y/N):		ate:		Run	Start Stop	*NR1* *NR2*	
Sequence ID/ Work Center II 200 * 7	)	Operation Description Pressure Wash per QSI0 Memo	05 4.3	Set Up/ Run Hours 0.00	Tool ID	Tool # Pla Coo		ept Rej Qty		Reject Insp. Number Stamp	-5,
210 *210* Powdercoat Powder Coating	841	White Gloss(Ref.4.3.5.1)  Memo START TIM OVEN TEM FINISH TIM	16: 10 - 40 19ERATURE: 30	0.00 2007			Ιχ	<u> </u>	<u>/</u> .	M -12/	1/
220 *220*	•	QC3- Inspect Part Finish	[[-10	0.00						91	10

0.00

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Quality Control

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W/O:			WC	RK ORDER CHA	NGES	2				
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:	Fault Categ	gory:	NCI	R: Yes I	No <b>DQ</b>	A:	Date:	
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NCR:		V	WORK ORDER NON-CONF							
DATE	STEP	Description of NC			Section B	0:	Verific		Approval	Approval
DAIL	J.L.	Section A	Initial Chief Eng	Action Description Chief Eng	on 	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Work Orde May-29-12 2:56		928		*849	728*						Pag
Item ID: Revision ID: Item Name:	D209-669-04 Replacement S			Accept	*N900	<b>040</b>	100	<b>)</b> * ፡	Setup Sta	1 \	IS1* IS2*
Start Date: Required Date: Reference:	29/05/2012 16/07/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item I Customer:	D:		•			11. 12
Approvals:	Process Plan	n:	Date:	Tooling: SPC (Y/N):		ate:		F	Run Sta Sto	17	IR1* IR2*
Sequence ID/ Work Center II 230 *230* HandFinish Hand Finishing		insert holes A/R Sika Sikaflex exp  2-Coat D25 per Dwg D2	before installing wearpla aftex-291 Mill ( ) bire date: 13 ( ) 94-3 O' rings with Petrole	cum Jelly and install on D2		Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	,

4-Install D2855 Fwd & Aft Cap as per Dwg D2906 and seal Fwd & Aft Cap with Sikaflex. Clean excess adhesive

A/R Sikaflex-291 //// / 4 G

Sikaflex expire date:

- 5-Wing Walk as per Dwg D2906 and QSI 005 4.4 Batch: M(1) (3)

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W/O:			WO	RK ORDER CHANGE	S			•	
DATE	STEP	PRO	CEDURE CHAN	IGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	;	PAR #:	Fault Categ	ory:	NCR: Yes	No <b>DQ</b>	A:	Date: _	
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Item ID: Revision ID: Item Name:	D209-669-0			Accept	*N90	0040	100	<b>)</b> *	Setup Sta	1.71	S1*
Start Date: Required Date: Reference:	29/05/2012	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Iten Custome					* <b>^</b> N	S2*
Approvals:	Process Pla	an:	Date:	Tooling:		Date:		J	Run Sta	rt *N	R1*
	QC:		Date:	SPC (Y/N):		Date:			Sto	<sup>op</sup> *N	R2*
Sequence ID/ Work Center II	)	Operation Description QC5- Inspect part com	pleteness to step on W/O	Set Up/ Run Hour	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
* <b>?</b> 40*		Memo	•	0.00	Enlose						
Quality Control		Inspect Afi Foreign ob	t Cap, Fwd Step and Wing V jects per QSI 024	Walk of work to Curr	ent Step Inspect for						
250				0.00							
*250* Packaging		Packaging Memo		0.00					<u>[[e</u>	12/5	123
Packaging		Identify an	d pack for shipping as per P	PPD209-669-043						, ,	,

260

QC21- Final Inspection - Work Order Release

0.00

\*260\*

Memo

0.00

Quality Control

MUS 12107/23

W/O:			WC	RK ORDER CHANGES	3				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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## **Picklist Print**

May-29-12 2:56:26 PM

Work Order ID: 84928

\*84928\*

Parent Item: D209-669-043

\*D209-669-043\*

Parent Item Name:

Replacement Skidtube

**Start Date:** 29/05/2012

**Required Date:** 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

new IPP 08.02.13 LL, verified by: DD

IPP Rev:B remove DT # in seq140 DD 10.03.10 Verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4202-1		Manufactured	No				Each	81.0000		19			
*D4202-1*				B84	1763				**	19	Œ	12-1-4	1-
				Location	!	Loc	<u>Oty</u>	Loc Code					
				LG			5				_		
					77727		5		_	-,	-		
				LG002	70006		76			<del></del> .	-		
					78806 79810		6 70				-		
D2500-1-190		Manufactured	No			110	Each	91.0000	1	1	-		
*D2500-1- Ext'n - I' Beam Tube 4"	190*						•		**		CF	12.6	-18
				Location	!	Loc		Loc Code					
				HALL	2000		91		_		-		
				Á	8000		14 77		-		-		
D2926-3		Manufactured	No	0		110	Each	0.0000		1	-		
*D2926-3*				Both	JOUC				**		_ CF	12.	6-19
D2855		Manufactured	No	\$8°	1771	230	Each	21.0000	2	2		٠.	
*D2855*					,				**	HI	12/6	210	5
				Location		Loc (	<u>Oty</u>	Loc Code				,	
- 4				FP002			21				-		
					65519 73347		2						
				,	75074		16 3			<u>۷                                    </u>			

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DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	NCR: Yes	No <b>DQ</b>	A:	_ Date: _	4
	R	esolution:	Dispositio	n: <u>'</u>	QA: N/C Clo	osed:		Date: _	
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DATE	STEP	Description of NC		Corrective Action Section		Verific	cation	Approval	Approval
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May-29-12 2:56:26 PM

Work Order ID: 84928 \*84928\* D209-669-043 Parent Item: \*D209-669-043\* Parent Item Name: Replacement Skidtube **Start Date: 29/05/2012 Required Date: 16/07/2012** Start Qty: 1.00 Required Qty: 1.00 AN3-5A Purchased No 230 Each 1,090,000 \*AN3-5A\* ? x 1107/05 \*\* Location Loc Oty Loc Code ST350 1090 115371 46 117423 124 118626 31 119355 200 120187 500 121185 189 AN960JD10L NAS1149D0332J Purchased No 230 Each 0.0000 \*AN960.ID101 \*\* 11015114 Washer ALS7-1032-130 Purchased Each 2,136.000 \*AI S7-1032-130\* V ALSH-1032-130 / MIZIZG9

<u>Location</u>	Loc Qty	Loc Code	
ST280	51		
117717	27		
118966	22		<del></del>
119775	2		
ST282	2085		
119530	73		
120181	12		
121444	2000		

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W/O:			W	ORK ORDER CHAN	GES					77
DATE	STEP	PROC	CEDURE CHA	ANGE	By	/	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	•	PAR #:	_ Fault Cate	egory:	NCR: Y	es N	o <b>DQ</b> .	A:	Date: _	
	R	esolution:	_ Disposition	on: <u>'</u>	QA: N/	C Clos	sed:		Date: _	
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DATE	STEP	Description of NC			ection B		Verific	cation	Approval	Approval
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May-29-12 2:56:26 PM

Work Order ID: 84928

\*84928\*

Parent Item:

D209-669-043

Parent Item Name: Replacement Skidtube

\*D209-669-043\*

**Start Date: 29/05/2012** 

**Required Date: 16/07/2012** 

Start Qty: 1.00

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Required Qty: 1.00

AN3C4A

Purchased

No

230

Each

1,458.000

12/07/05

\*AN3C4A\*

<b>Location</b>	<u>Lo</u>	c Oty	Loc Code		
ST350		1458			
120187		57			
120521		28			
120769		38			
121205		1000			X44
121556		335			
	230	Each	0.0000	44	44

AN960C10L

NAS1149C0332 Purchased

No

11127063

\*AN960C10I \*√

washer

D2594-3

Manufactured No 230

Each 2,418.000

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\*D2594-3\* O-Ring, 205 Skidtube

<b>Location</b>	Loc Qty	Loc Code
FP001	2418	
65518	41	
79496	984	
79573	50	
<u>79755</u>	1343	

W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	<b>A</b> :	_ Date: _	<del></del>
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DATE	STEP	Description of NC			ion B	Verifi	cation	Approval	Approval
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May-29-12 2:56:26 PM

Work Order ID: 84928 \*84928\* Parent Item: D209-669-043 \*D209-669-043\* Parent Item Name: Replacement Skidtube Start Date: 29/05/2012 **Required Date: 16/07/2012** Start Qty: 1.00 Required Qty: 1.00 D2594-1 Manufactured No 230 Each 311.0000 14 14 \*D2594-1\* noalos \*\* Plug, 205 Skidtube Location Loc Code Loc Oty FP001 73401 30 74442 18 79495 50 FP-A 213 73401 0 78590 213 D3564-9 Manufactured No 230 Each 22.0000 \*D3564-9\* 12/07/05 \*\* Wearshoe Location Loc Qty Loc Code FG 76950 FP001 18 67590 69943 82255 13 D3564-11 Manufactured No 230 8.0000 Each \*D3564-11\* \*\* Wearshoe Location Loc Qty Loc Code FG 383910 77056

FP001

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W/O:			WO	RK ORDER CHANGE	S				**********
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Part No		PAR #:	Fault Categ	jory:	NCR: Yes	No DQ	<b>A</b> :	_ Date: _	<del></del>
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NCR:			WORK ORDE	R NON-CONFORMA	NCE (NCR	)			
DATE	STEP	Description of NC		Corrective Action Section			cation	Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sect	ion C	Chief Eng	QC Inspector
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#### **Picklist Print** Page 5 May-29-12 2:56:26 PM Work Order ID: 84928 \*84928\* Parent Item: D209-669-043 \*D209-669-043\* Parent Item Name: Replacement Skidtube **Required Date: 16/07/2012** Start Date: 29/05/2012 Start Qty: 1.00 Required Qty: 1.00 D3564-5 Manufactured 230 Each 13.0000 \*D3564-5\* \*\* 91 1207/US Wearshoe Location Loc Qty Loc Code FG 2 34806 2 FP001 11 77609 3 82254 8 D3566-1 Manufactured 230 Each 31.0000 \*D3566-1\* 12/07/0 \*\* Gasket Location Loc Qty Loc Code FP -22 81619 10 FP002 53 68924 2 80919 3 83898 16 D3566-5 Manufactured 230 Each 21.0000 \*\* Il 17/07/05 Gasket

\*D3566-5\*

Location Loc Qty Loc Code FP 12 82275 12 FP002 9 80374 3 82274

Dart Aerospace	Ltd	
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Dart Ae	rospace L	td							۴ د
W/O:			WORK ORDER C	HANGES		18 41 80		***************************************	
DATE	STEP	PRO	OCEDURE CHANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Category:	NCR	: Yes	No DQA:		Date:	
	Res	olution:	Disposition:	QA:	N/C CI	osed:		_ Date: _	
NCR:			WORK ORDER NON-CONF	ORMANCE	(NCF	R)	-		
DATE	STEP	Description of NC	Corrective Action		Sign &	Verifica		Approval	Approval

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
		Description of NC		Corrective Action Section B		Verification	Approval	Approval QC Inspector			
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng				
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																			,	. 10.			1	2	105	5/	129
SKIDTUBE ASSEMBLY	SKIDTUBE ASSEMBLY		EXTRUSION	CROSS BOLT SPACER	PLUG	O-RING	AFT CAP	WEB	WEB	WEARSHOE (REPLACES D2577-1)	WEARSHOE (REPLACES D2577-3)	WEARSHOE (REPLACES D2577-5)	WEARSHOE	GASKET	GASKET	GASKET		INSERT			BOLT	BOLT	WASHER	WASHER		,	TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED. LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES. INSERT D2926-1/23 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOARD WEB INTO OUTED IT DE WITH MOST BY INCHES.
D2906-041	D2906-043		D2500-1-190	D2579	D2594-1	D2594-3	D2855	D2926-1	D2926-3	D3564-9	D3564-11	D3564-5	D3564-15	D3566-1	D3566-5	D3566-15		ALS7-1032-130	or AKS7-1032-130	or AKS4-1032-130	AN3C4A	AN3-5A	AN960C10L	AN960JD10L			PER DART QSI 018 UNI EXTRUSION BEFORE WEB TO LOCATION SH
	×		1	19	14	14	2		1	1	1	1		2	1			44			4	4	4	4	TES	j	ES ARE F D2500- 926-1/-3 V
×			1	22	12	12	2	-		1	1	1	1	2	1	1		20			20	4	20	4	N		DLERANC ENGTH O SERT D2
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	D2906-041	D2906-041 X D2906-043	D2906-041 X D2906-043	X D2906-041 X D2906-043 1 D2500-1-190	X D2906-041 SKIDTUR   X D2906-043 SKIDTUR   1 D2500-1-190 EXTRUS   19 D2579 CROSS	D2906-041  X D2906-043  1 D2500-1-190  19 D2579  14 D2594-1	X D2906-041 SKIDTUR X D2906-043 SKIDTUR 1 D2500-1-190 EXTRUS 19 D2579 CROSS 14 D2594-1 PLUG 14 D2594-3 O-RING	X D2906-041 SKIDTUR X D2906-043 SKIDTUR 1 D2500-1-190 EXTRUS 19 D2579 CROSS 14 D2594-1 PLUG 14 D2594-3 O-RING 2 D2855 AFT CAF	X D2906-041 SKIDTUR   X D2906-043 SKIDTUR   1 D2500-1-190 EXTRUS   14 D2594-1 PLUG   14 D2594-1 PLUG   14 D2594-3 O-RING   2 D2855 AFT CAF   D2855 AFT CAF	X D2906-041 SKIDTUR   X D2906-043 SKIDTUR   1 D2500-1-190 EXTRUS   14 D2594-1 PLUG   14 D2594-1 PLUG   14 D2594-3 O-RING   2 D2855 AFT CAF   1 D2926-1 WEB	X D2906-041 SKIDTUBE ASSEMBLY     X D2906-043 SKIDTUBE ASSEMBLY     1 D2500-1-190 EXTRUSION     14 D2594-1 PLUG     14 D2594-1 PLUG     2 D2855 AFT CAP     1 D2926-1 WEB     1 D3926-3 WEB     1 D3926-3 WEB     1 D3564-9 WEARSHOE (REPLACES D2577)	X D2906-041 SKIDTUBE ASSEMBLY     X D2906-043 SKIDTUBE ASSEMBLY     1 D2500-1-190 EXTRUSION     14 D2594-1 PLUG     14 D2594-1 PLUG     2 D2855 AFT CAP     1 D2926-1 WEB     1 D3564-9 WEARSHOE (REPLACES D2577     1 D3564-1 WEARSHOE (REPLACES D2577	X D2906-041 SKIDTUBE ASSEMBLY     X D2906-043 SKIDTUBE ASSEMBLY     1 D2500-1-190 EXTRUSION     14 D2594-1 PLUG     14 D2594-1 O-RING     2 D2855 AFT CAP     1 D2926-3 WEB     1 D3564-1 WEB     1 D3564-1 WEARSHOE (REPLACES D2577     1 D3564-5 WEARSHO	X D2906-041 SKIDTUBE ASSEMBLY     D2906-043 SKIDTUBE ASSEMBLY     1 D2500-1-190 EXTRUSION     14 D2594-1 PLUG     14 D2594-1 PLUG     14 D2594-1 O-RING     1 D2926-1 WEB     1 D2926-1 WEB     1 D3564-9 WEARSHOE (REPLACES D2577     1 D3564-1 WEARSHOE (REPLACES D2577     1 D3564-5 WEARSHOE (REPLACES D2577     D3564-1 WEARSHOE (REPLACES D2577	X D2906-041 SKIDTUBE ASSEMBLY     D2906-043 SKIDTUBE ASSEMBLY     1 D2500-1-190 EXTRUSION     14 D2594-1 PLUG     14 D2594-1 PLUG     14 D2594-3 O-RING     1 D2926-1 WEB     1 D3264-9 WEARSHOE (REPLACES D2577     1 D3564-11 WEARSHOE (REPLACES D2577     1 D3564-15 WEARSHOE (REPLACES D2577     D3564-15 WEARSHOE (REPLACES D2577     D3564-15 WEARSHOE (REPLACES D2577     D3564-15 WEARSHOE (REPLACES D2577     D3564-16 WEARSHOE (REPLACES D2577     D3566-1 GASKET     D3566-1 GASKET     D3566-1 GASKET     D3568-1 GASKET     D35	X         D2906-041         SKIDTUBE ASSEMBLY           X         D2906-043         SKIDTUBE ASSEMBLY           1         D2906-043         SKIDTUBE ASSEMBLY           19         D2579         CROSS BOLT SPACER           14         D2594-1         PLUG           14         D2594-3         O-RING           2         D2955-3         AFT CAP           1         D2955-1         WEB           1         D2956-1         WEB           1         D3564-1         WEARSHOE (REPLACES D2577           1         D3564-5         WEARSHOE (REPLACES D2577           1         D3564-5         WEARSHOE (REPLACES D2577           2         D3564-1         WEARSHOE (REPLACES D2577           2         D3566-1         GASKET           1         D3566-1         GASKET	X         D2906-041         SKIDTUBE ASSEMBLY           1         D2906-043         SKIDTUBE ASSEMBLY           1         D2500-1-190         EXTRUSION           14         D2594-1         PLUG           14         D2594-3         O-RING           2         D2855         AFT CAP           1         D2926-1         WEB           1         D2926-3         WEB           1         D3564-1         WEARSHOE (REPLACES D2577           1         D3564-5         WEARSHOE (REPLACES D2577           1         D3564-5         WEARSHOE (REPLACES D2577           2         D3564-15         WEARSHOE (REPLACES D2577           1         D3564-5         WEARSHOE (REPLACES D2577           2         D3564-1         WEARSHOE (REPLACES D2577           2         D3564-1         WEARSHOE (REPLACES D2577           1         D3566-1         GASKET           1         D3566-1         GASKET           1         D3566-1         GASKET           1         D3566-1         GASKET	X         D2906-041         SKIDTUBE ASSEMBLY           1         D2906-043         SKIDTUBE ASSEMBLY           1         D2500-1-190         EXTRUSION           14         D2579         CROSS BOLT SPACER           14         D2594-3         O-RING           2         D2855         AFT CAP           1         D2926-3         O-RING           1         D2926-1         WEB           1         D3564-1         WEARSHOE (REPLACES D2577           1         D3564-5         WEARSHOE (REPLACES D2577           1         D3564-1         WEARSHOE (REPLACES D2577           2         D3564-1         WEARSHOE (REPLACES D2577           1         D3564-1         WEARSHOE (REPLACES D2577           2         D3564-1         WEARSHOE (REPLACES D2577           1         D3566-1         GASKET           1         D3566-1         GASKET           1         D3566-1         GASKET           1         D3566-15         GASKET	X         D2906-041         SKIDTUBE ASSEMBLY           1         D2906-043         SKIDTUBE ASSEMBLY           1         D2500-1-190         EXTRUSION           14         D2594-1         PLUG           14         D2594-3         O-RING           2         D2955-3         AFT CAP           1         D2926-3         WEB           1         D3564-9         WEARSHOE (REPLACES D2577           1         D3564-10         WEARSHOE (REPLACES D2577           1         D3564-11         WEARSHOE (REPLACES D2577           2         D3564-15         WEARSHOE (REPLACES D2577           1         D3564-15         WEARSHOE (REPLACES D2577           2         D3564-15         WEARSHOE (REPLACES D2577           1         D3564-15         WEARSHOE (REPLACES D2577           2         D3564-15         WEARSHOE (REPLACES D2577           1         D3564-15         WEARSHOE (REPLACES D2577           2         D3566-15         GASKET           1         D3566-15         GASKET           2         D3566-15         GASKET	X   D2906-041   SKIDTUBE ASSEMBLY     D2906-043   SKIDTUBE ASSEMBLY     1	X D2906-041 SKIDTUBE ASSEMBLY     D2906-043 SKIDTUBE ASSEMBLY     1 D2500-1-190 EXTRUSION     14 D2594-1 PLUG     14 D2594-1 PLUG     14 D2594-1 PLUG     14 D2594-1 PLUG     14 D2594-1 WEB     1 D2926-3 WEB     1 D3564-9 WEARSHOE (REPLACES D257     1 D3564-1 WEARSHOE (REPLACES D257     1 D3564-1 WEARSHOE (REPLACES D257     1 D3564-1 WEARSHOE (REPLACES D257     1 D3566-1 GASKET     1 D3566-1 GASKET     2 D3566-1 GASKET     0 ASS7-1032-130 OF AKS7-1032-130 OF A	X   D2906-041   SKIDTUBE ASSEMBLY     X   D2906-043   SKIDTUBE ASSEMBLY     1   D2500-1-190   EXTRUSION     14   D2559   CROSS BOLT SPACER     14   D2594-1   PLUG     14   D2594-1   PLUG     14   D2594-1   PLUG     15   D2926-1   WEB     1   D3564-9   WEARSHOE (REPLACES D2577-1)     1   D3564-9   WEARSHOE (REPLACES D2577-3)     1   D3564-15   WEARSHOE (REPLACES D2577-3)     2   D3564-15   WEARSHOE (REPLACES D2577-5)     3   D3564-15   WEARSHOE (REPLACES D2577-5)     4   ALS7-1032-130   INSERT     0   OF AKS7-1032-130   OF AKS4-1032-130     0   OF AKS4-1032-130   OF AKS4-1032-130     0   OF AKS4-1032-130   OF AKS4-1032-130     0   OF AKS	X   D2906-041   SKIDTUBE ASSEMBLY     X   D2906-043   SKIDTUBE ASSEMBLY     1   D2500-1-190   EXTRUSION     14   D2559   CROSS BOLT SPACER     14   D2594-1   PLUG     14   D2594-1   PLUG     14   D2594-1   PLUG     15   D2926-3   WEB     1   D3564-9   WEARSHOE (REPLACES D2577-1)     1   D3564-9   WEARSHOE (REPLACES D2577-3)     1   D3564-15   WEARSHOE (REPLACES D2577-3)     1   D3564-15   WEARSHOE (REPLACES D2577-3)     2   D3564-15   WEARSHOE (REPLACES D2577-3)     3   D3566-1   GASKET     4   ALS7-1032-130   INSERT     5   Or AKS7-1032-130   Or AKS4-1032-130     5   Or AKS4-1032-130   Or AKS4-1032-130     6   Or AKS4-1032-130   Or AKS4-1032-130     7   AN3-5A   BOLT	X	X   D2906-041   SKIDTUBE ASSEMBLY     1	D2906-041   SKIDTUBE ASSEMBLY	NO. <u>84978</u> 12/05/ 12/05/

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1) CLEARANCES ARE PER DARI USING UNLESS OF HERWISE NOTED.
2) LENGTH OF D2500-1 EXTRUSION BEFORE BENDING = 190 INCHES.
3) INSERT D2926-1-3 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-24/1291

ADHESIVE PER DART QSI 015 BEFORE BENDING. ENSURE HOLES LINE-UP.
4) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200

IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
5) BEND AS A SMOOTH RADIUS STARTING WITH A MAXIMUM REDUCTION OF 0.200

IN DIAMETER IS ALLOWABLE IN THE BENT PORTION OF THE TUBE.
6) USE DART DRILL TEMPLATE D72906-041) OR D72906-0437

TO LOCATE AND DRILL 20.297 HOLES FOR WEARSHOE INSERTS. INSTALL ALS7.

1032-130 PER SECTION C-C AFTER FINISH. INSTALL AN3C4A BOLTS AND AN960C10L

WASHERS WITH SIKAFLEX-24/1/291. 6

F 8

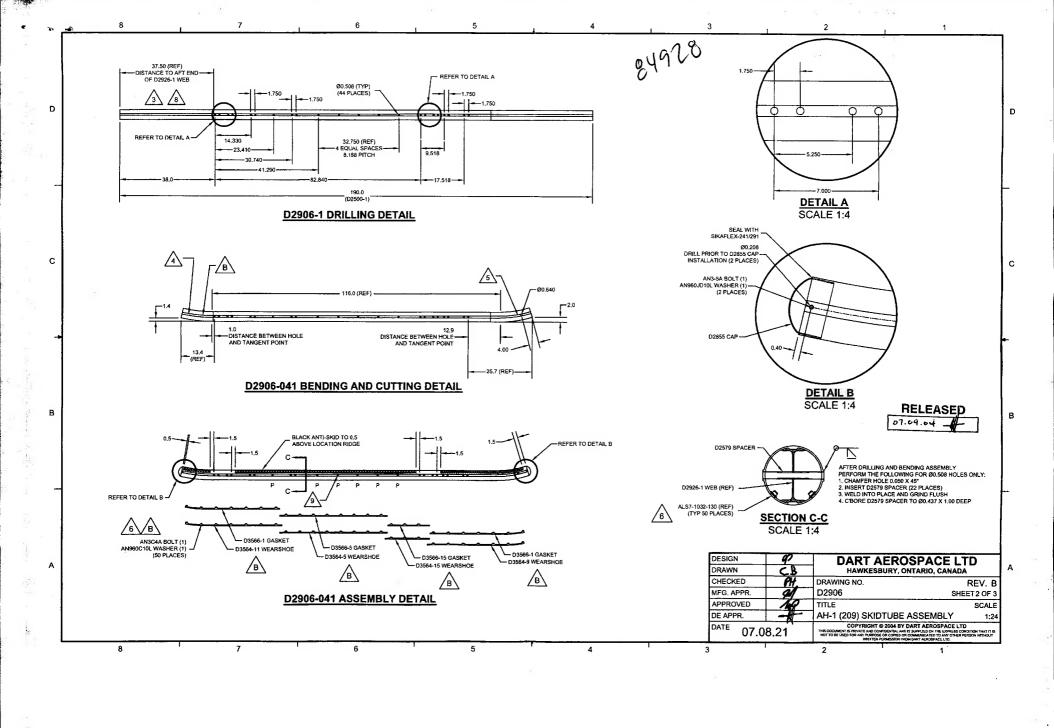
FINISH

ACID ETCH, ALODINE PER DART QSI 005 4.1 PRIOR TO INSERTING D2926-1/-3
ACID ETCH, ALODINE PER DART QSI 005 4.3
WEB. POWDER COAT ASSEMBLY WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED PER DART QSI 005 4.4
9) INSERT D2594-1 PLUG CWV D2594.3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE) AFTER FINISH (12 PLACES).
10) ALL DIMENSIONS ARE IN INCHES.

RELEASED 40.04.04

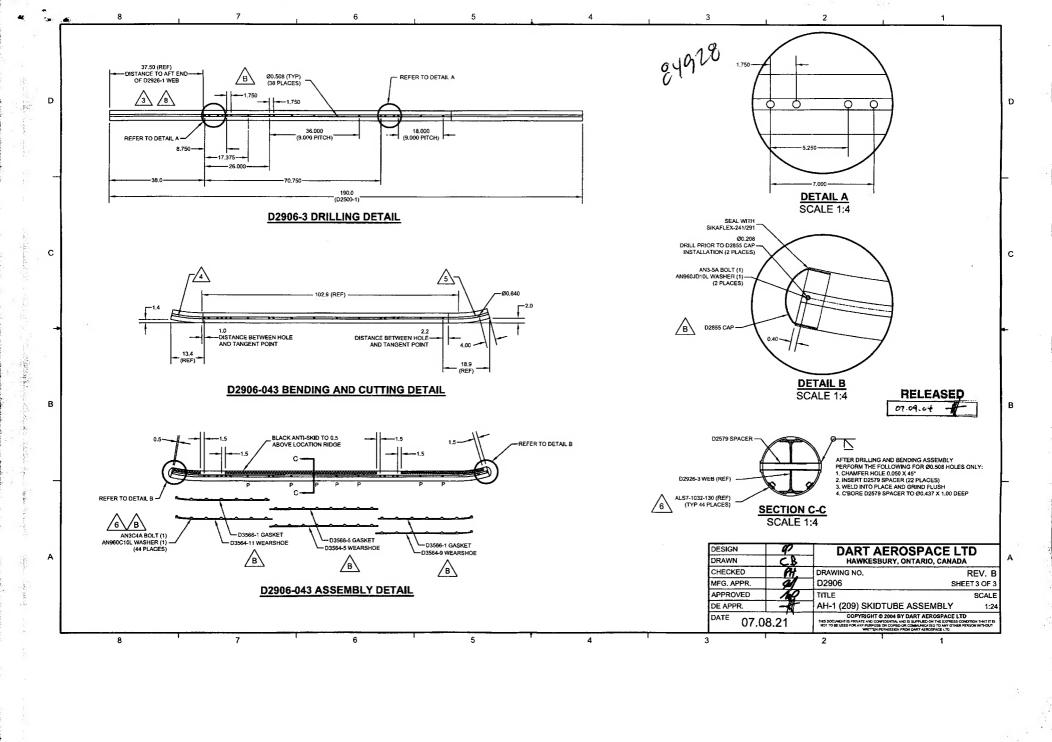
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NTS	<b>MBLY</b>	AH-1 (209) SKIDTUBE ASSEMBLY	A P	ج.	DE APPR.
SCALE		TITLE	00	APPROVED	Š
SHEET 1 OF 3	S	D2906	lis	MFG. APPR.	Ą.
REV. B		DRAWING NO.	Ж	Q:	CHECKED
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04.06.22	မ		SSUE	NEW ISSUE	4
		PG 3 C3: CORRECTED -043 CAP P/N; PG 3 D7: 38 PLACES WAS 44 PLACES;	3: CORRECTE 7: 38 PLACES	PG3C PG3D	
7.00.10	3	PG 2 C7: REMOVE AFT Ø0.640 HOLE FROM -041;	7: REMOVE AF	PG 2 C	,
07.08.21	ă		PG 1: ADD NOTE 10:	PG 1: /	œ
		CHANGE WEARPLATE HARDWARE TO SS;	<b>3E WEARPLAT</b>	CHANC	
		ADD STAINLESS STEEL WEARPLATES AND GASKETS	TAINLESS STE	ADD S	
		UPDATE DRAWING FORMAT; RE-ORGANIZE;	'E DRAWING F	UPDAT	

W/O:			W	ORK ORDER CHANG	GES							
DATE	STEP	PRO	CEDURE CH	ANGE	8	У	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector		
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NCR:		V	WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC	Imiain		ction B	ign &	Verific		Approval	Approval		
		Section A	Initial Chief Eng	Action Description Chief Eng		Date	Secti	on C	Chief Eng	QC Inspector		
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DATE	OTED	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
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DATE	STEP	Description of NC			ction B	Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign of Date	Section	on C	Chief Eng	QC Inspector
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